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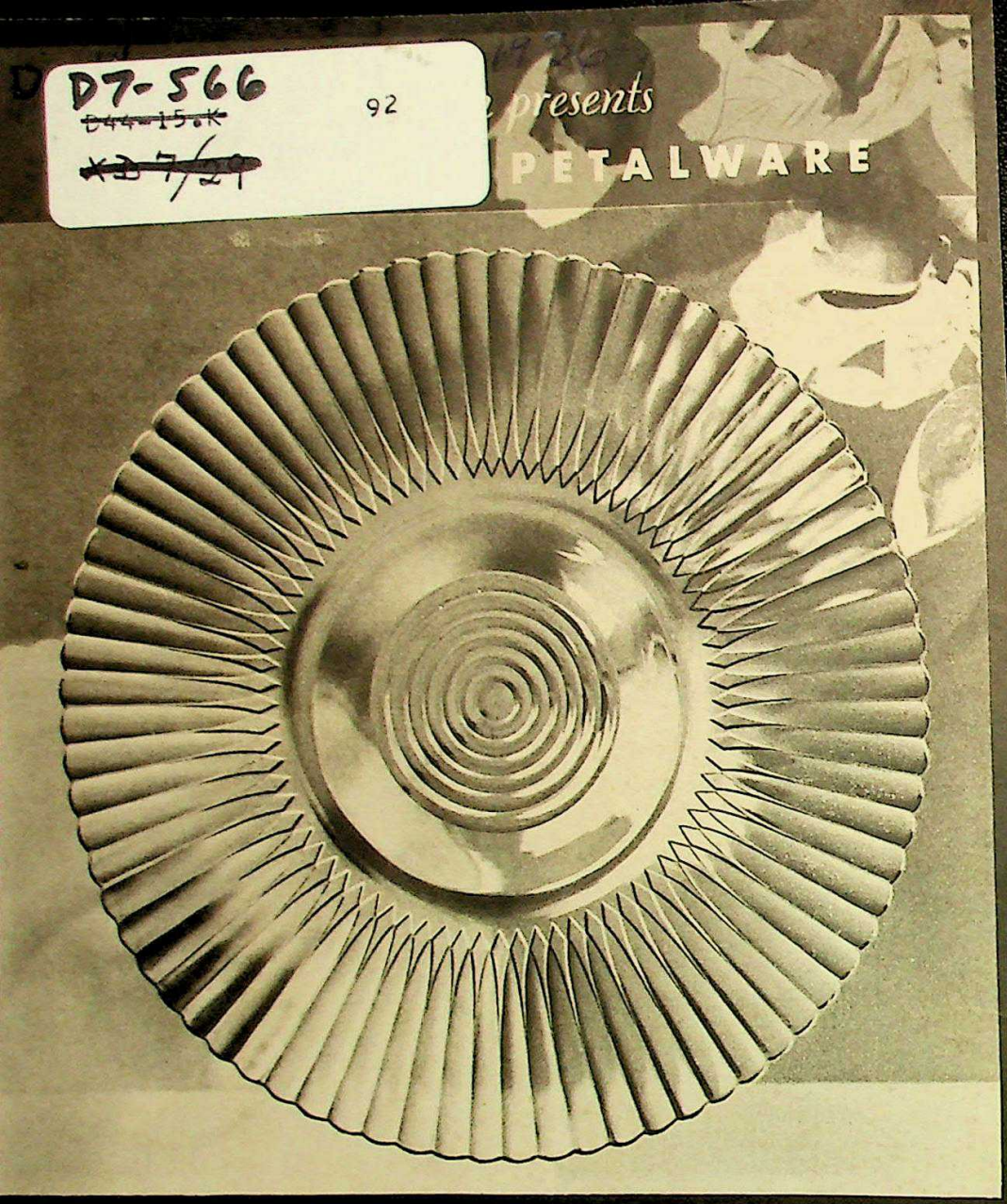


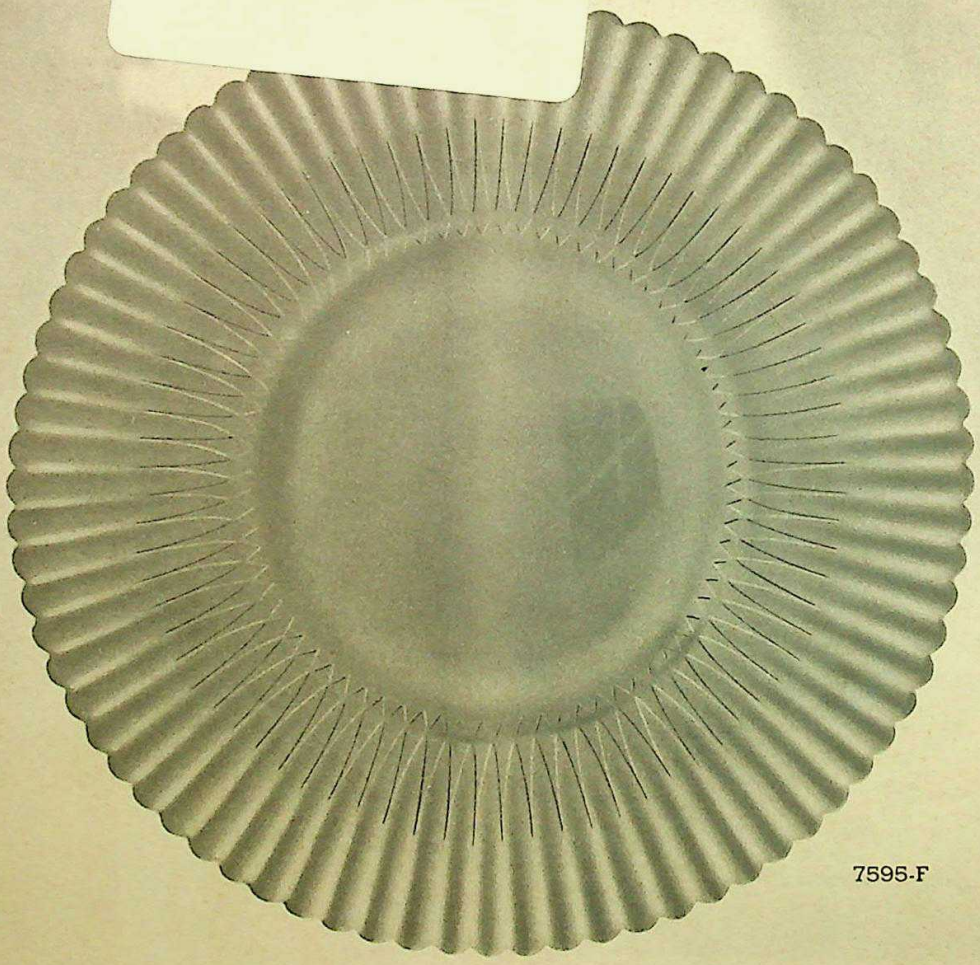
● Here is a bargain in beauty . . . A combination of Macbeth's lovely, translucent rose pink color that has proved its great popularity and Macbeth's famous Petal Pattern that has made such a "hit" with American housewives . . . It's a complete line, available in various sets —sets that look like expensive glassware in every respect—sets that will be offered to you at very attractive prices . . . Macbeth Rose Pink Petalware is a line for you to build on . . . A premium that has what it takes to develop big volume sales . . . Glassware that you can be sure will not be "footballed" but rather will be retailed by the better department stores at good high prices. Write for details of this brand new Macbeth line. Address Macbeth-Evans Glass Company, Charleroi, Pa.

D7-566 C.R.

Page 6 - Premium Practice Sept. 1936.

A Bargain in BEAUTY

~~D44-15.6~~ 92



Modern in motif, beautiful in its blue-white translucence and harmonious with all table decorations, this new complete line by Macbeth has everything it takes in a premium to stimulate volume sales . . . Macbeth Monax Petalware has a rich look of quality that in no way indicates its very attractive price . . . An instant appeal to buying eyes that builds business. Write for our complete Monax Petalware Catalogue. Macbeth-Evans Glass Company, Charleroi, Pa.

MACBETH MONAX PETALWARE

D-44
9.92
Page 37
Premium Practice of July 1937.

D44-9.C 92

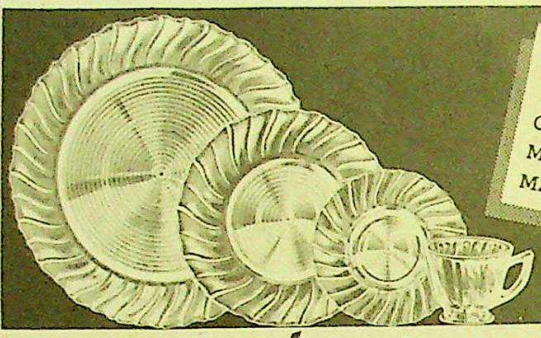
products just because of some premium that was offered, but always a product she could use. She cited a popular make of cheese spread that was packed in small decorative glasses, and the whole family wanted a complete set, so she kept on buying.

Her children are confirmed premium senders, sending for almost everything they see advertised, although her own judgment was that while they were worthwhile, as far as the children were concerned, as to their value, there weren't many of them that were worth the dime they cost, but for the children she thought they justified the cost for the excitement of getting them. Her advice to the premium user was to give an article of value, either as to quality or as to usefulness, to the woman in the home.

The fourth juror was a business girl who keeps house in an apartment with her sister. Her preference as to premiums was for something practical, useful and not easily duplicated. As to paying for a premium, she said:

> "If it is a good one, I am willing to pay. There isn't much difference whether it is 10c or 25c. If it is one coin that you can put in an envelope and send easily, it doesn't make much difference. I don't think they are fooling us when they say 'Ten cents to cover cost of handling.' We understand their joke. We might have higher respect for the donor if the premium were very unusual, and were free. For example, the rice industry got out the most attractive cook book of the season and theirs was absolutely free; you didn't have to send a label, a coupon or anything. In contrast, Libby's got out a very outstanding color cook book, and also Heinz. They got out a salad and a meat cook book and for both of those you had to send either money or a label. After I had had all three of these books I definitely felt a little closer feeling to the rice industry because I felt they really were giving us something, and I think it increased my use of rice."

This candid juror secured a set of biscuit cutters with a prepared flour and they carried the name of the product on the handle, which was not objectionable, as they remained in the kitchen, reminding her where she got them. On the contrary, she received a set of individual aluminum jelly molds with a gelatine dessert, and doesn't remember the product. She urged not too much



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JEANNETTE, PA.

FOR CRYING OUT LOUD!!
WHO RUINED MY HAT?
POOR FELLOW—HE DOESN'T KNOW IT'S A JOKE!

But it was his very best "Sunday" hat! Looks like the pencil is pushed through the hat which will leave an unsightly hole.

Nay, not so . . . for 'tis a simple little joke, that is harmless and lots of fun. And as an advertising medium, for good will building, to get good results for a small sum of money, you can't beat it. If you want to know more about it, write for sample and prices.

We have so many other items in our line to select from—*nice things*, something to suit every need. Here are a few: Glass Paper Weights, Lead Pencils, Novelty Pencils, Sewing Kits, Mirrors, Fly Swatters, Thermometers, Whetstones, Needle Books—you'll find them illustrated and priced in our catalog; all you have to do is to ask for it. Several of our items are copyrighted, registered or patented which means that they are not sold by every Tom, Dick and Harry! This is worth investigating.

SANDERS MANUFACTURING COMPANY
Established 1918
"America's Foremost Manufacturers of Advertising Specialties"
Dept. X 124-26 Fourth Ave. South NASHVILLE, TENN.

THE DEALER PREMIUM WHICH PLACES YOUR ADVERTISEMENT ON EVERY PACKAGE

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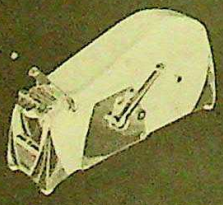

As modern and efficient as its streamlined case indicates. Simple, too. Just a stoke of the lever and length of gummed tape (2 in. or 4 in. or 6 in.) is moistened, cut and ejected. No gears or gadgets to go wrong—simple—sure—steady.

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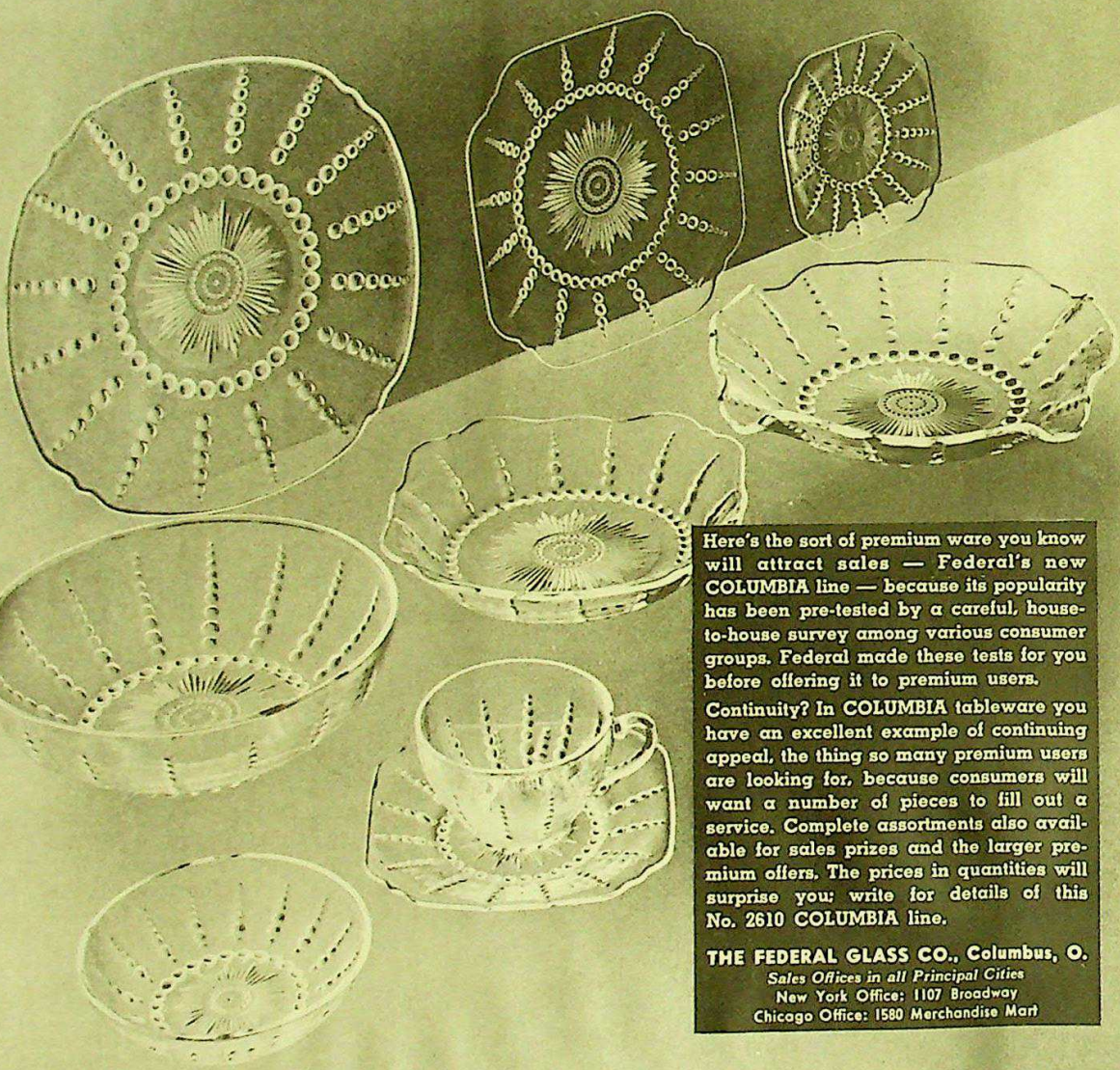
Hail "Columbia"

FEDERAL'S NEW PRE-TESTED TABLEWARE



Here's the sort of premium ware you know will attract sales — Federal's new COLUMBIA line — because its popularity has been pre-tested by a careful, house-to-house survey among various consumer groups. Federal made these tests for you before offering it to premium users.

Continuity? In COLUMBIA tableware you have an excellent example of continuing appeal, the thing so many premium users are looking for, because consumers will want a number of pieces to fill out a service. Complete assortments also available for sales prizes and the larger premium offers. The prices in quantities will surprise you; write for details of this No. 2610 COLUMBIA line.

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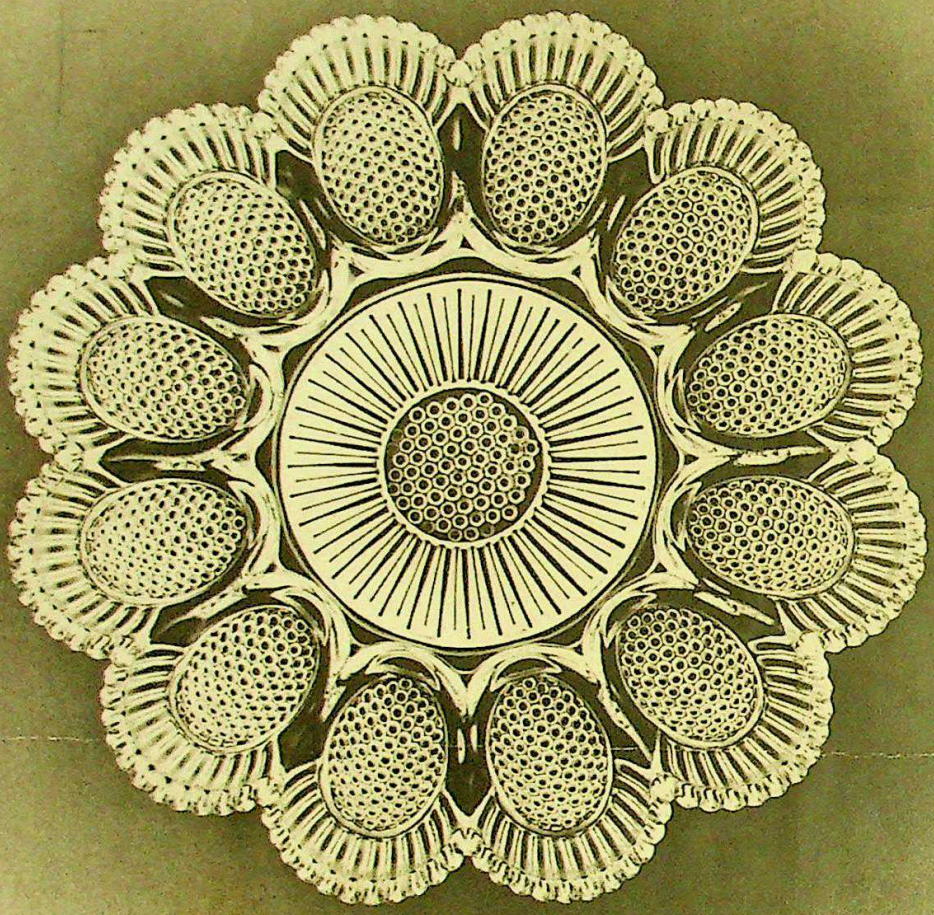
FEDERAL

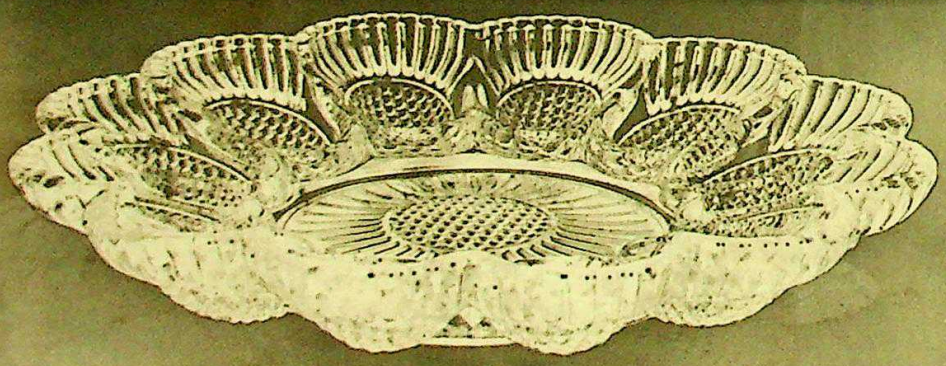
Tumblers: Machine blown, Hand blown, Paste Mold and Pressed — Stemware — Tableware — Kitchenware—Beverage Sets—Decorated Ware — Special Premium Glassware and Novelties.

Feb. 1941.

D-36 / 6 cut

NOW $7.20 PER DOZEN IN LOTS OF TWO DOZEN





No. 23135, CRYSTAL GEORGIAN PLATE TO HOLD 12 DEVILLED EGGS. $7.20 PER DOZEN IN TWO DOZEN LOTS. $9.00 PER DOZEN IN LOTS LESS THAN TWO DOZEN. 10" IN DIAMETER.

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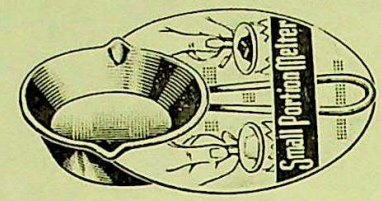
ONE CUP COFFEE MEASURE

A useful novelty item, small enough to fit in coffee can or bag. Attractively enameled in assorted colors, Ivory, Blue, Green, and Red. Each mounted on two-color card describing usage. Packed in assorted colors only.

Number	Size	Doz. Per Carton	Weight Per Dozen
9T	1⅞x ⅝"—2½" Handle	12	½ lb.

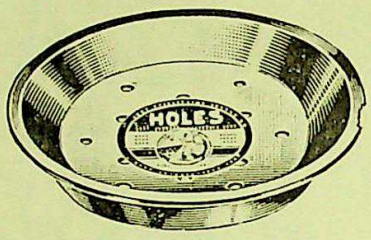


SMALL PORTION MELTER

There are many uses for this handy little pan, for melting butter, squares of chocolate, etc. Made of full weight tin with tinned wire handle 2½ inches long. Pouring lips on both sides of pan. Each mounted on two-color descriptive card

1	3¼x ⅞"	12	1¼ lbs.

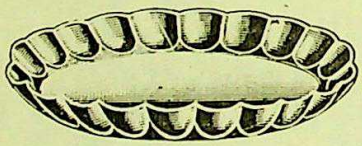
Catalog no. 41
7-30-1947
page 12



PERFORATED PIE PLATES

These perforated pie plates bake better pies with better, crispy bottom crusts. They have standard 15 hole perforations, each plate has a descriptive colored label.

909	9 x1¼"	3	3½ lbs.
910	10 x1⅜"	3	4 lbs.

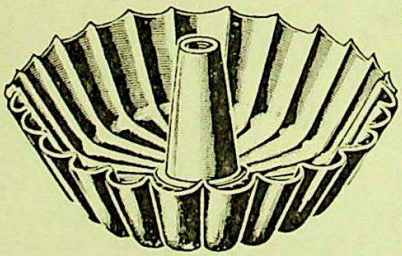


SCALLOPED PIE PLATES

These pie plates were designed to be a very practical novelty and may be used for cakes, pies, gelatins, etc. They are made of heavy, bright tin plate with all edges hemmed for safety.

509	8¾x1¼" (no hemmed edge)	3	3¼ lbs.
509-H	8¾x1¼" (with hemmed edges)	3	3¼ lbs.

(Cat. in metal files Des. Lib.)



KRINKLE CAKE PANS

Popular, fast selling, unusual cake pans—made of bright heavy tinplate with all edges hemmed. Made with or without tube in center of pan.

78	9½x2⅞" (with tube)	2	5 lbs.
79	9½x2⅞" (without tube)	2	4½ lbs.

CHECKERED MARBLE CAKE PAN SET

An unusually fast selling novelty cake pan set consisting of three pans and one set of patented Self-Centering rings that positively lock in place on pans. Easy to use, full directions and recipes on individual two-colored display carton.

400	9 x1⅜"	2	18 lbs.

CORNING
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FEB, 1974 P. 50
BETTER HOMES & GARDENS
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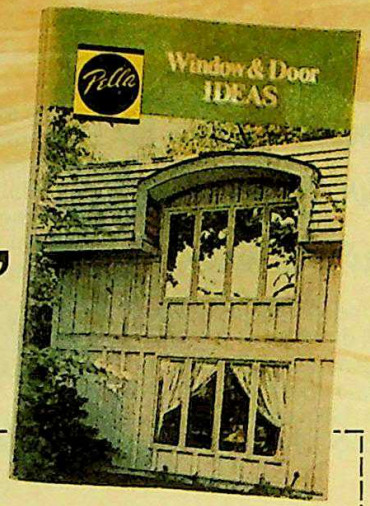
for traditional and contemporary homes.



If you're thinking about building, buying or remodeling, this 16-page book on window and door selection can be very helpful. Find out how Pella Windows can eliminate storm and screen chores. How you can cut outside maintenance to a minimum with our exclusive Pella Clad exterior. And how you can reduce heating and air conditioning costs with our Double Glazing System. All windows are not created equal. So before you select the windows for your next home, send for your copy. Fully-illustrated, in color, and yours free.

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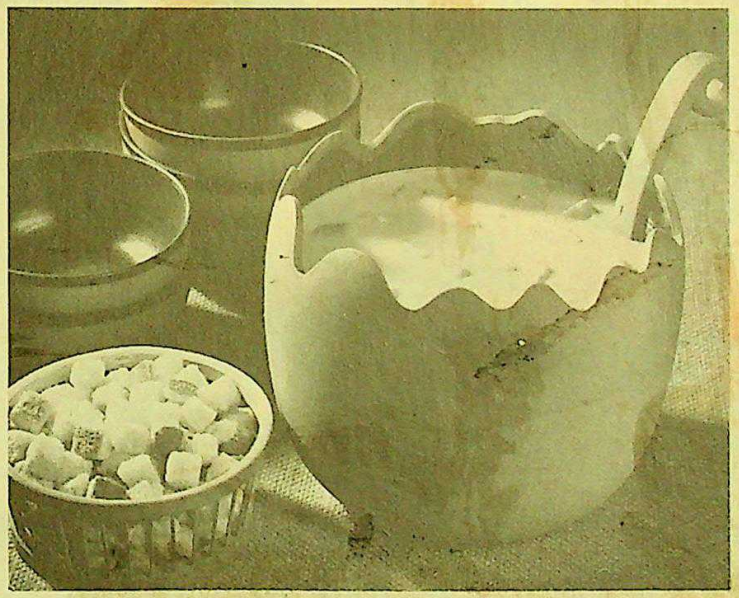
Buying information, page 121

ONION HAM AND CHEESE CHOWDER

A money-stretching main dish that provides hearty eating—

2 medium potatoes, pared and cubed (2 cups)
½ cup boiling water
1 cup chopped onion
3 tablespoons butter or margarine
3 tablespoons all-purpose flour
Dash pepper
3 cups milk
1½ cups chopped fully cooked ham
1½ cups (6 ounces) shredded sharp process American cheese

Cook cubed potatoes in the boiling water till tender, about 10 minutes. Drain, reserving liquid. Add enough water to reserved liquid to make 1 cup. In saucepan, cook onion in butter or margarine till tender but not brown. Blend in flour and pepper. Add milk and potato water all at once. Cook and stir till mixture thickens and bubbles. Add chopped ham and shredded sharp process American cheese; stir to melt cheese. Ladle into soup bowls. Serve with toasted croutons, if desired. Makes 8 servings.



D 7/29

Platten-Schalen

pelbarock folgt im 17. Jahrhundert der die Pflanzenwelt so ungemein verherrlichende Akanthusbarockstil. Die schöngeformten großen Blätter des Akanthus (Bärenklau) beleben die Fläche der Fahne, großformatige Blüten und Knospen (Sonnenblumen, Tulpen) quellen hervor.

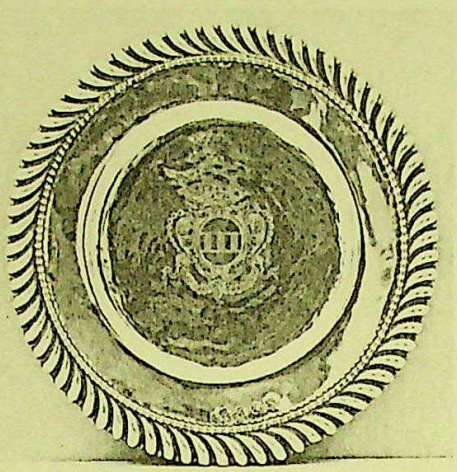
Durchmesser 23,7 cm.

Meister Wolfgang Spitzenberg, wird 1673 Meister, gestorben 1684.

6. Barock, Augsburg. Um 1700.
Lavabo (lateinisch: ich werde waschen). Kirchliches Waschbecken mit Kanne zum Gebrauch für den Geistlichen. Der von einer Perlschnur begrenzte Rand der Fahne ist aufgebogen und mit schräggestellten Knorren besetzt (so nannten die Kölner Goldschmiede dieser Zeit treffend die gerippten Ornamente, die man mit dem Ausdruck „Godronen" zu bezeichnen pflegt. Der Spiegel zeigt gewölbte Muschelrippen um einen Mittelkreis herum, in den die Kanne hineinpaßt. Die Klarheit der Formensprache, die strenge Abgrenzung der einzelnen Teile ist von großer Schönheit, sie hat nichts „Barockes" sondern eher etwas Klassisches an sich. man wird an das antike Beispiel (Abb. 1) erinnert.

Durchmesser 53,5 cm.

Meister Johann Mitnacht, gestorben 1727.



7. Barock, Wesel. 1704.
Kleiner Brotteller zum Abendmahl in der reformierten Kirche. Hier wird geschnittenes Brot gereicht an Stelle von Oblaten, der Teller muß also größer sein als bei Patenen der katholischen und protestantischen Kirche. Markantes Ornament: die leicht geschwungenen, schräg angeordneten Knorren des Randes. Typisch barock die reiche Gestaltung des gravierten Wappens im Spiegel (Akanthusvoluten, Lorbeergehänge usw.).

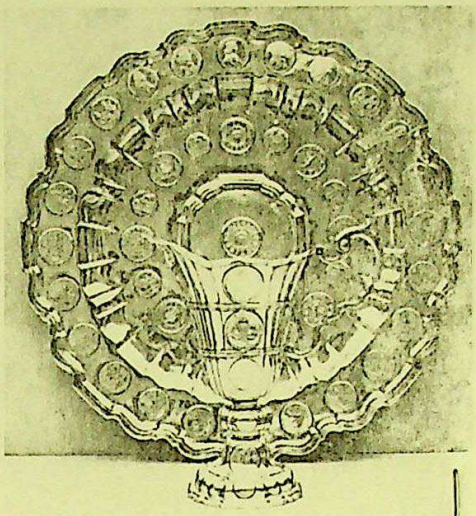
Durchmesser 17,5 cm; die beiden zugehörigen großen Brotteller dieser Kirche messen 24 cm im Durchmesser.

Meister Arnold Hüding, wird 1694 Bürger; gestorben 1753.

8. Barock, Régence. Bielefeld. 1718.
Platte. Das schlichte Kreisrund wird jetzt belebt. Der Spiegelrand ist achtpassig gekurvt und profiliert, während der Umriß der Fahne mehr wellenförmig verschliffen ist. Hier ein kleinteiliges Feldermuster mit den für den Régencestil so charakteristischen „Blatttropfen". (Régence = Zeit der Regentschaft in Frankreich nach dem Tode Ludwigs XIV., des Sonnenkönigs, 1715.)

Durchmesser 26,5 cm.

Meister Peter Feuerberg, 1703–1720 nachweisbar.



9. Barock, Régence. Hamm/Westfalen. 1730.
Prunkbecken und Helmkanne mit 65 eingelegten Münzen für ein westfälisches Schloß. Tisch-Waschbecken, wohl auch als Taufgerät benutzt. Während bei den vorigen Beispielen nur aneinandergereihte Kurven als Begrenzung des Spiegels zu sehen waren, ist hier eine starke Zerklüftung des Umrisses zu erkennen. Kurven verschiedener Länge wechseln mit geraden Abschnitten ab. Das Spiel wiederholt sich in der Mitte des Spiegels in dem Achteck, bei dem die Abschnitte der ungeraden Seiten doppelt gekurvt sind. Der Fuß der Helmkanne paßt in dies Achteck hinein. Wie bei dem vorigen Beispiel auf der Fahne die Trennungsstriche der kleinen Felder radial angeordnet sind, so sind bei diesem Becken die Abschnitte der Kehle zwischen Fahne und Spiegel durch radiale Grate gegliedert, die noch in den Spiegel einschneiden. Wie waagerechte und — nahezu — senkrechte Linien sich durchdringen, zeigt deutlich der Corpus der Kanne in Form eines auf den Kopf gestellten „Helmes". Trotz der Vielfalt des Einzelnen sind klare Grundformen gewahrt.

Durchmesser 57,5 cm.

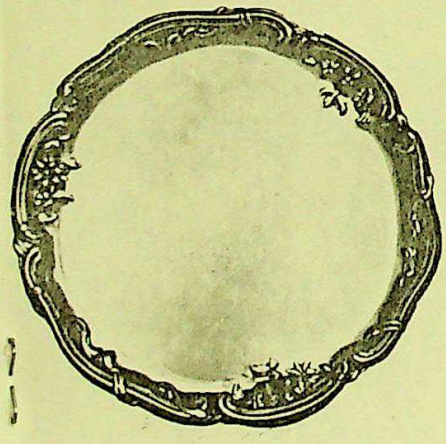
Meister Christian Hövel, heiratet 1707, lebt noch 1743.

GOLDSCHMIEDE ZEITUNG 6/1977 p. 32

(OVER) ↓

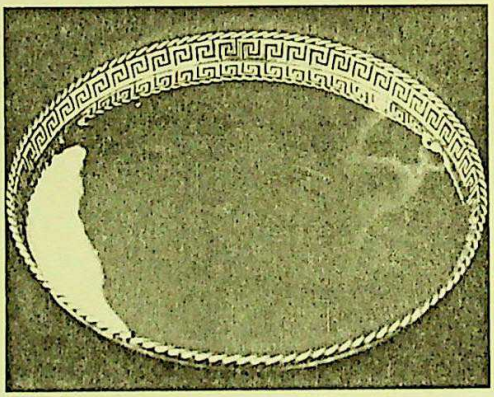
D7-566

10. Rokoko, Augsburg. 1749–51.
Becken und Helmkanne. Wie anders ist hier die Formengebung bei gleichem Zweck des Objektes, bei gleicher Größe! Das „Architektonische", Gebaute ist völlig aufgegeben, zugunsten einer schwingenden, flatternden Bewegung. Die gerade Linie ist völlig ausgemerzt, klare Abgrenzungen sind durch weichfließende Übergänge ersetzt. Überall ist das Motiv der asymmetrischen „Rocaille" verwendet (französisch rocaille, abgeleitet von roc, Fels, eine Art Grotten- oder Muschelwerk), und zwar in einer etwas derben Ausführung. Die charakteristischen C-Kurvaturen lassen sich feststellen ebenso wie die ausgefransten „Muscheln".
Durchmesser 53,5 cm.
Meister C K M, wohl Silberarbeiter Caspar Kornmann, gestorben 1764 im Alter von 51 Jahren.

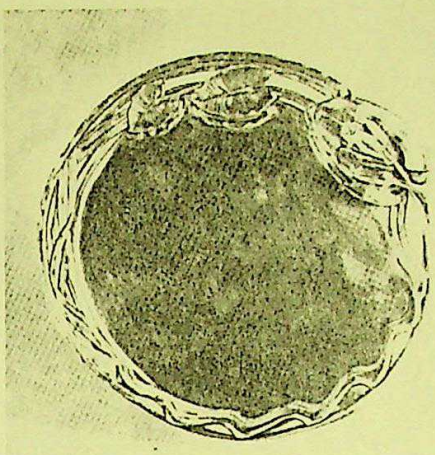


11. Rokoko, Berlin. Um 1775.
Tablett. Eine wesentlich einfachere, aber dafür feinere Arbeit als das vorige Beispiel. Der doppelsträhnige Rand ist sechsfach gegliedert: drei kurze konvexe Kurvaturen mit reizenden Blüten wechselnd mit drei längeren, wellenförmig verlaufenden, um die sich zarte Weinranken schlingen.
Durchmesser 27,1 cm.
Meister George Wilhelm Marggraff, wird ca. 1761 Amtsmeister, gestorben 1804.

12. Spätrokoko, Berlin. Um 1785.
Schale. Der Rand ist rosenblattartig sechspassig gekurvt, die Wölbung des Spiegels aber höchst wirkungsvoll mit „Zügen" in Windradform belebt. Das Windrad ist ein beliebtes Motiv des Frühklassizismus (Louis-XVI.-Stiles).
Durchmesser 25,4 cm.
Meister I S.



13. Klassizismus, Kassel. Um 1800.
Tablett. Den Rand umschließt ein Steg mit ausgesägtem Mäanderband, ein Taustab bildet den Abschluß. Dies griechische Ornament hat seinen Namen nach dem Fluß Mäander in Kleinasien, dessen Lauf durch seine starken Krümmungen auffiel. Amüsant zu sehen, wie sich der Mäanderfries durch Spiegelung verdoppelt.
Durchmesser 30 cm.
Meister Johann David Kröschel, wird 1784 Meister, gestorben 1826.



14. Jugendstil, Bremen. Um 1900.
Visitenkartenschale. Die Umrahmung bilden in reizvoller Weise zwei Seerosen mit Stengeln, Blättern und Blütenknospe. Ein Naturgefühl kommt zum Ausdruck, wie wir es vergleichsweise ähnlich bei dem Tablett von Marggraff (Abb. 11) fanden. Man darf an ein Gedicht von Christian Morgenstern denken, das ja auch in dieser Zeit entstand und das beginnt:
Wieviel Schönheit ist auf Erden
unscheinbar verstreut:
möcht ich immer mehr des inne werden
...
Durchmesser 24 cm.
Firma Martin Heinrich Wilkens und Söhne.

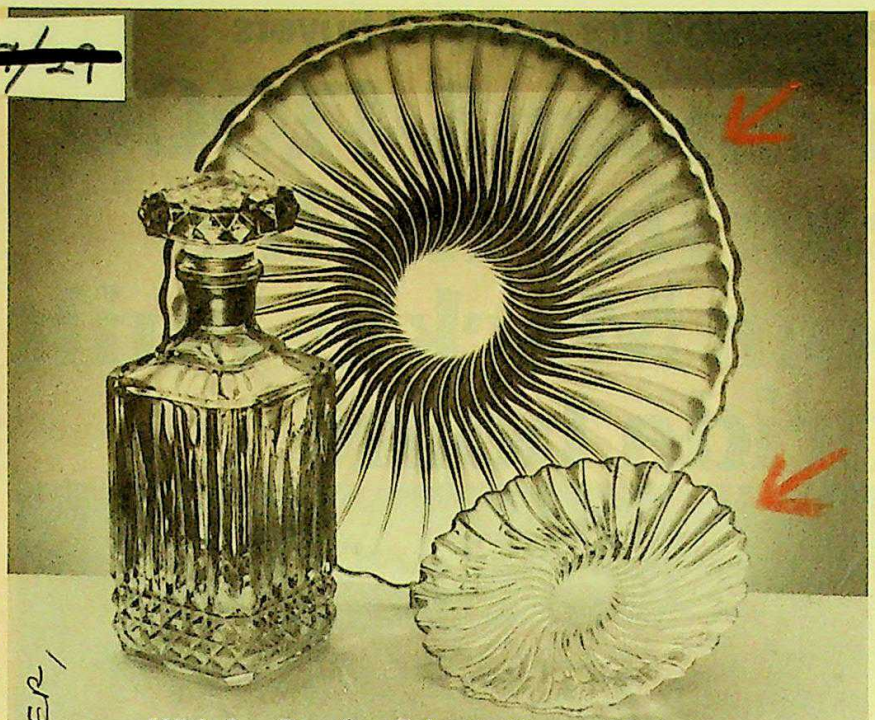
GOLDSCHMIEDE ZEITUNG
6/1977
p. 33

(OVER) ↓

~~D7-29~~ XR PAGE G-10 DECEMBER, 1981

D7-566

~~D7/29~~



BETTER HOMES & GARDENS DECEMBER, 1981 P. G10

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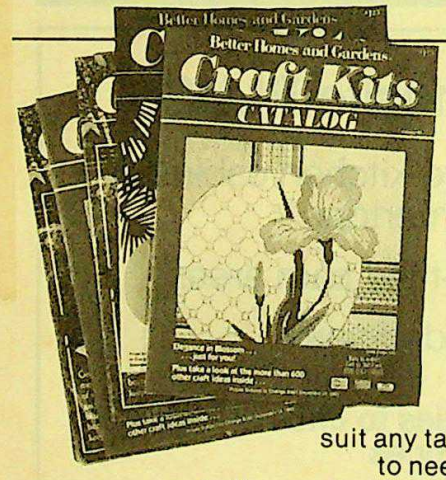

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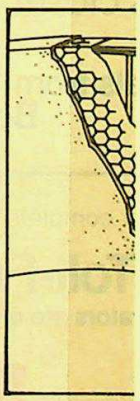

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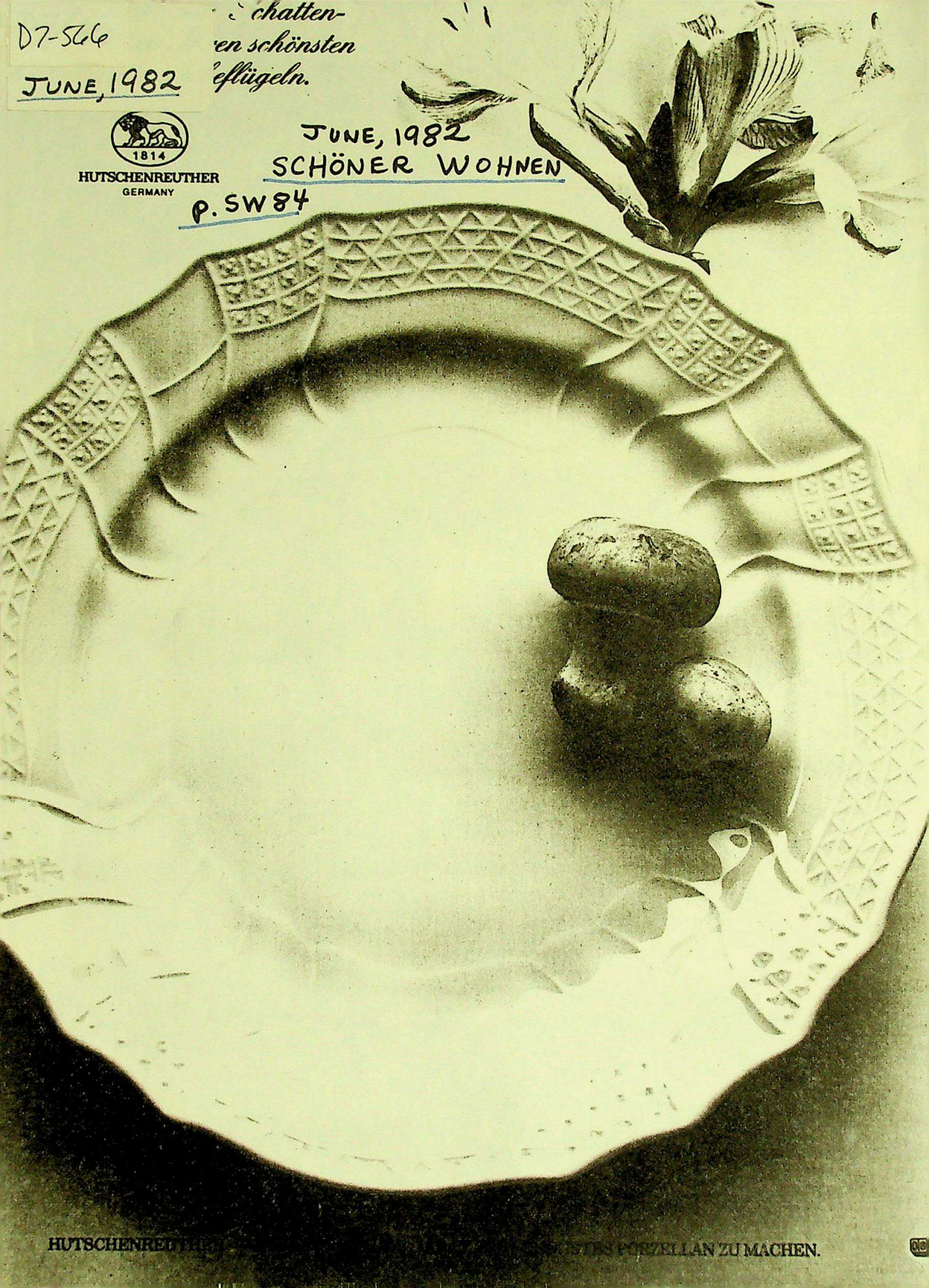

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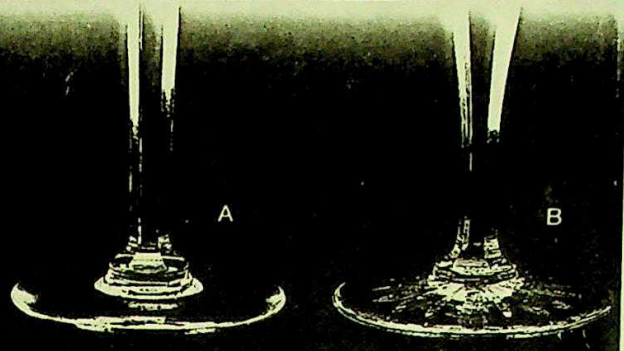

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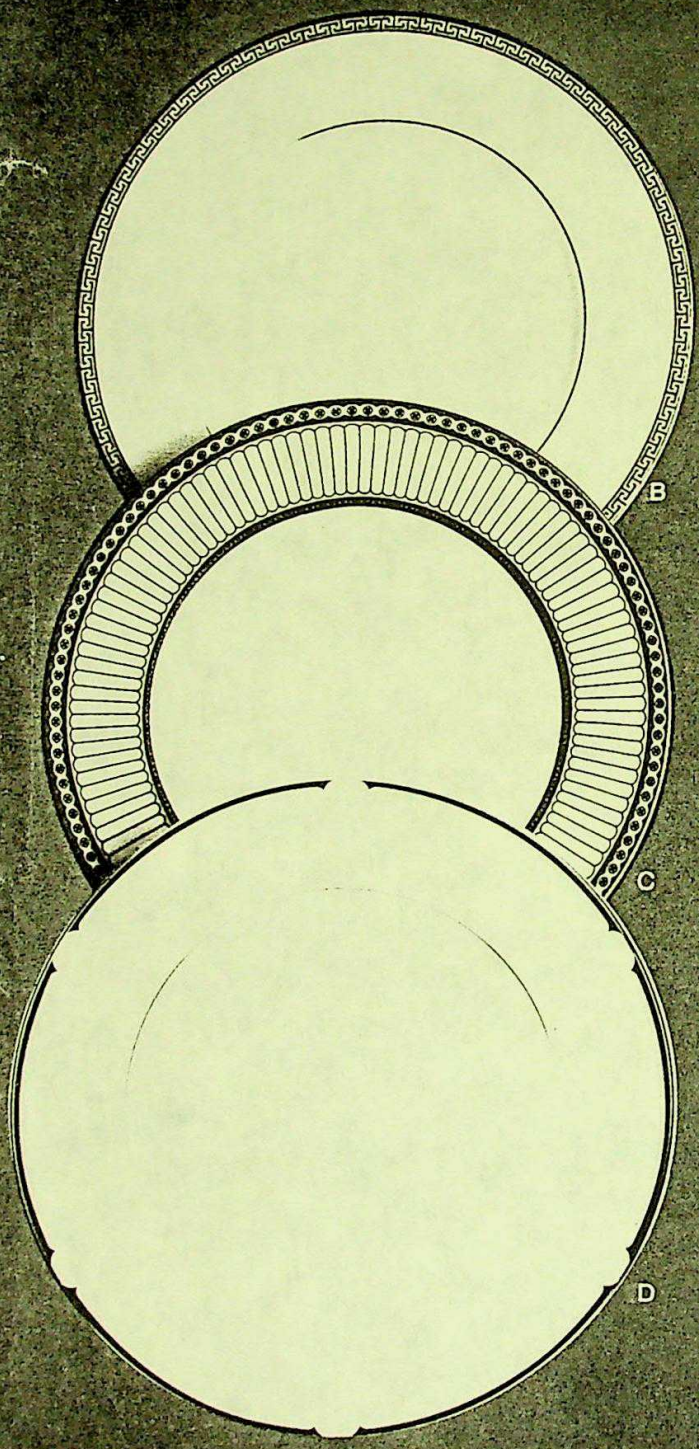

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MAY, 1985
TABLEWARE
INTERNATIONAL

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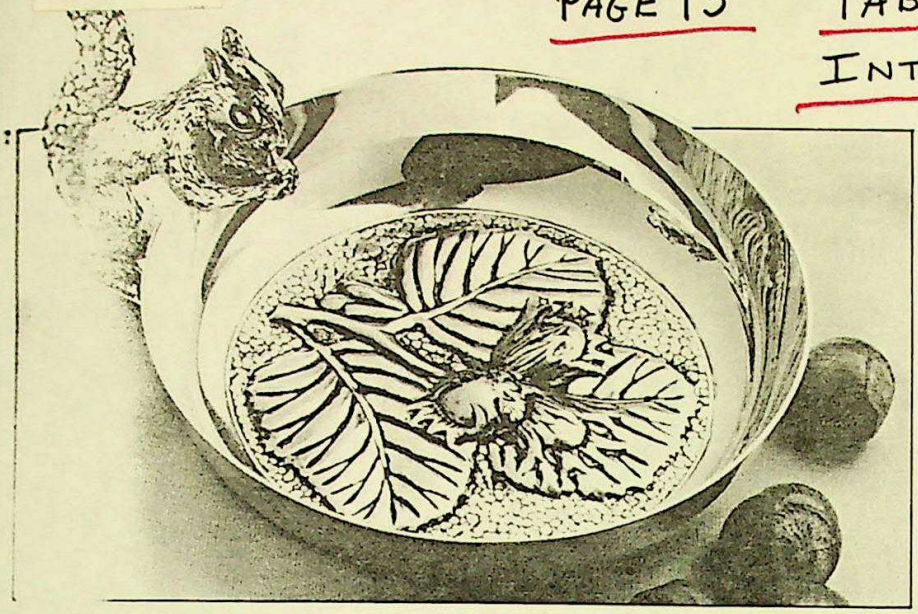

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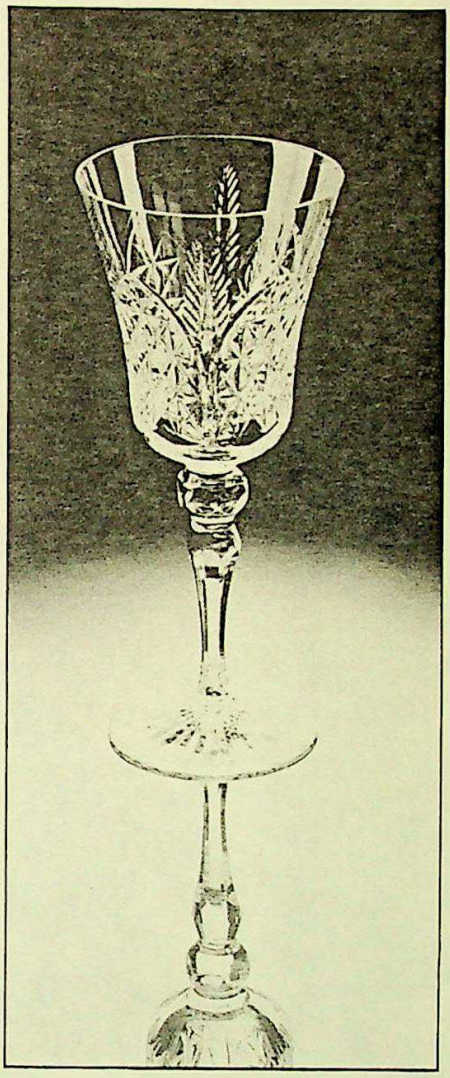

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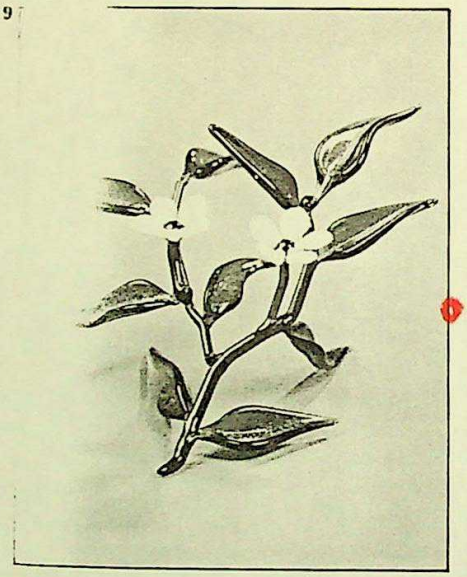

7 New from Sheffield-based Parkin Silversmiths is this delightful silver-plated nut dish

8 Two classical stemware ranges have been launched by Royal Brierley Crystal, namely 'Sovereign' and 'Viceroy' (which we picture)

9 The design from Scottish Dornoch Glass, specialists in delicately moulded glass flowers, shows a small branch of the Prunus variety.

10 Japanese porcelain manufacturers, The Yamago Company, has launched three distinctive designs featuring both geometric and organic forms in high relief on the rims

11 Striking metallic-finish table decorations from American Fitz & Floyd, reflect the latest in fashionable tabletop

continued on page 16

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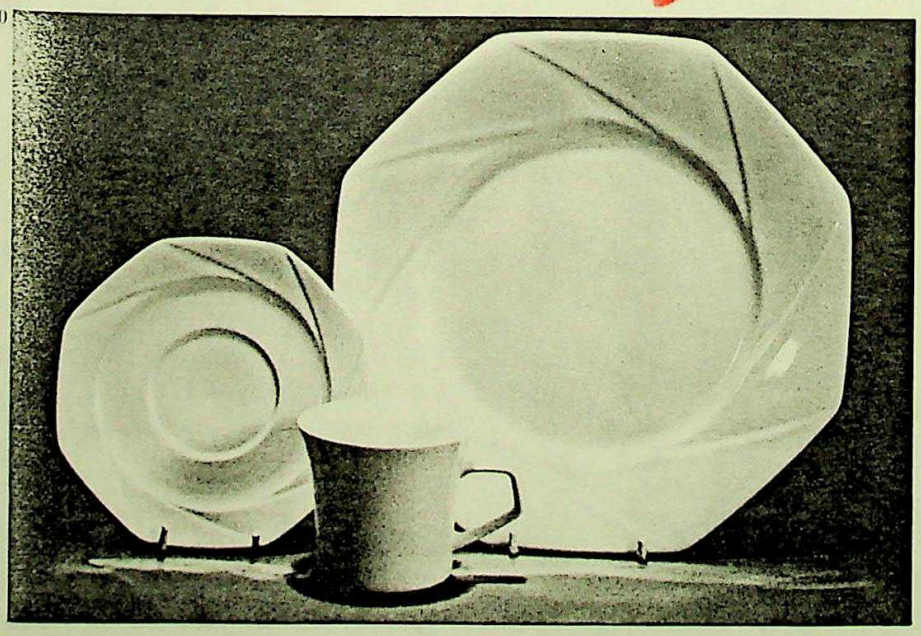

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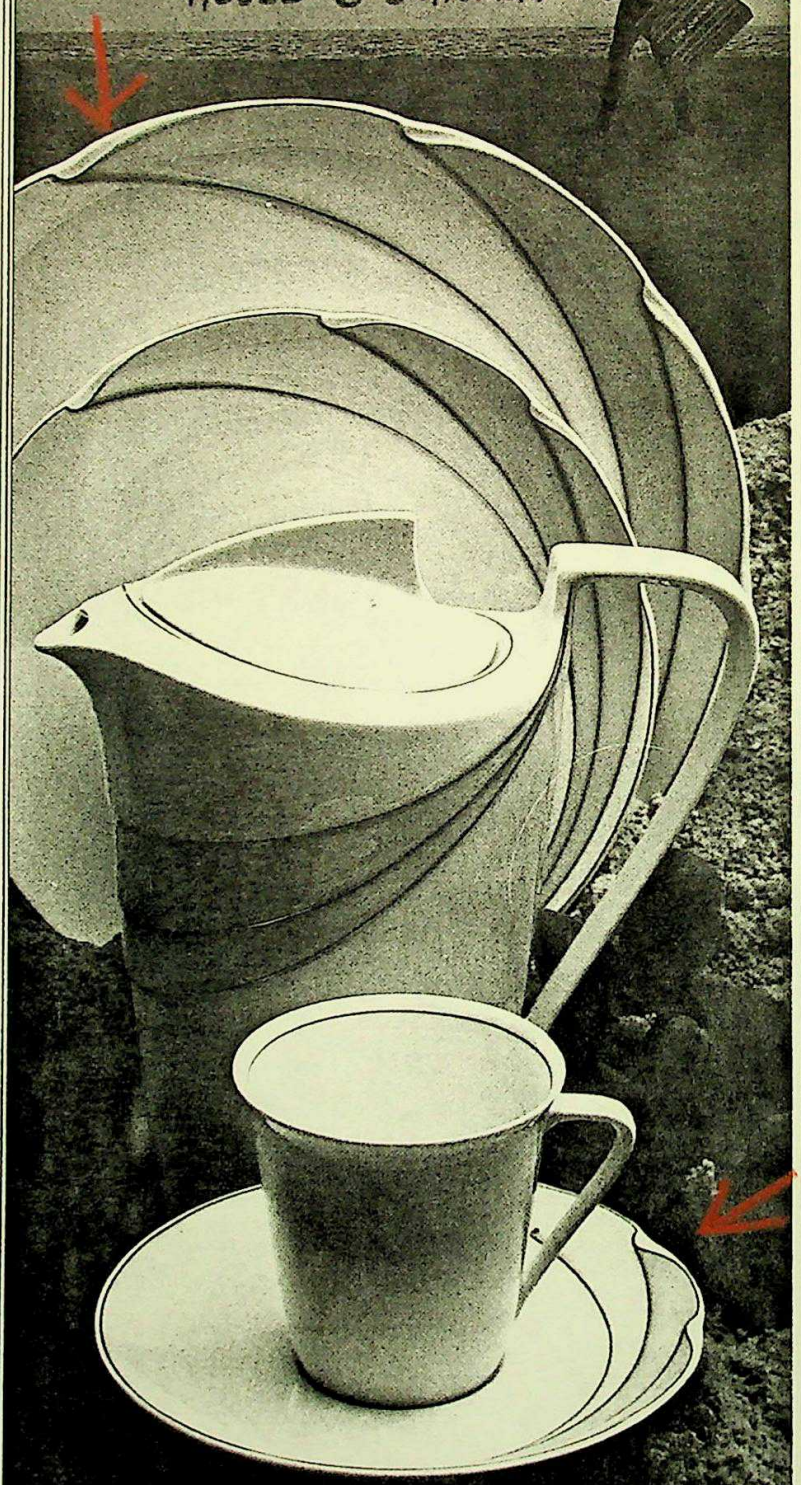

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PAGE 100

HOUSE & GARDEN

A bloodletting lintel from Yaxchilán

crumbling temple in the jungle, having suffered from both neglect and misguided attempts to preserve them. *The Murals of Bonampak* is one of the rare cases in art history where the treatise on a work is better than the work itself.

All three murals are wonderful in their way but the one in the second room is truly exquisite. (It also contains all the proof you need of the Maya's sanguinary practices.) In a kind of point/counterpoint, a battle scene of high intensity is followed by a court scene, as hushed and regimental as the former is loud and chaotic, where a royal figure (known to Mayanists as Chaan-muan) presides over the mutilation of captives. In achieving the artistry of utter chaos, this battle would find its modern cinematic equivalent (all a good many of us know of war) in one of Akira Kurosawa's battle scenes. For the grace of its composition, the mutilation scene is considered, rightfully, one of the great works of all times. Its finest touch is the Oriental positioning of the captives' hands, held up in final, futile supplication.

For twenty years Merle Greene Robertson has been doing for the art of Palenque what Miller has done for the murals of Bonampak. The task is a mammoth one. Palenque, a Maya site in the Mexican state of Chiapas, has the richest store of extant stucco sculpture of all the Maya ruins. Robertson has photographed and, where additional insight is helpful, made drawings of all of this work. She had to set up elaborate scaffolding, because of the placement of some of the sculptures, and she had to work at night with cumbersome lighting equipment, because the roof overhangs cast shadows on many of the pieces during the day. Robertson's is a labor of love, and that unabashed quality runs through these three volumes. Her motivation was doubtless partly the lure of Palenque itself—of all the Maya ruins everyone agrees that it possesses an uncanny magic—but also it was based on a fear that runs through the archaeological community that these sites will deteriorate, or be defaced or looted, or simply change. Even in the best of worlds, time and mother nature impose their fees. Palenque was pummeled by abrasive white ash when the volcano El Chichón

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Bullyland, New York, named Burdick Assoc. its national rep for educational channels. Stein & Assoc. will cover Metropolitan New York.

Riedel Crystal of America, Bohemia, N.Y., has named Rhodes Messick of Rhodes Messick Assoc. as representative for New York State, excluding metropolitan New York and Westchester County.

Kaiser Porcelain, Niagara Falls, N.Y., announces complete distribution in the U.S. through the following representatives: Brian Cleary, New York; Anthony Aversano, Florida; Bartke Assoc., Texas, Arkansas, Louisana, Oklahoma, New Mexico; Bob Cunningham, Minnesota and N. and S. Dakota; Bob Emory, N. and S. Carolina, Georgia, Alabama and Tennessee; Tom Hogan, eastern Pennsylvania, southern New Jersey, Maryland, Washington, D.C., Delaware and northern Virginia; Robert Watson, New England; Richard Dolan Inc. reps Ohio, western Pennsylvania, W. Virginia, eastern Kentucky, Indiana and Michigan. Harold & Lynn Levin cover California and Nevada. John Foster, Virginia; Bob Walker, Washington and Oregon; David Edward & Assoc., Kansas, Missouri, Nebraska and Iowa; and Lang-Zubin Assoc. will cover Illinois.

Kent Silversmiths, New York, has appointed Solinger Assoc. its sales representatives in the states of Indiana, Illinois, Minnesota and Wisconsin. Both principals are well-known to the Midwest tabletop community; Jeff Solinger, as the vice-president of Crate & Barrel; Bill Kennihan, as a general merchandise manager of Marshall Field Co.

Flute Inc., Chicago, has named Hitchcock Presents sales representative for its lamps and decorative accessories. Hitchcock will represent Flute in Texas, Oklahoma, Louisiana, Arkansas, Missouri, Kansas and Nebraska. Hitchcock Presents will be showing Flute in both of its showrooms: 222 World Trade Center, Dallas, and room 430, of the Kansas City Merchandise Mart.

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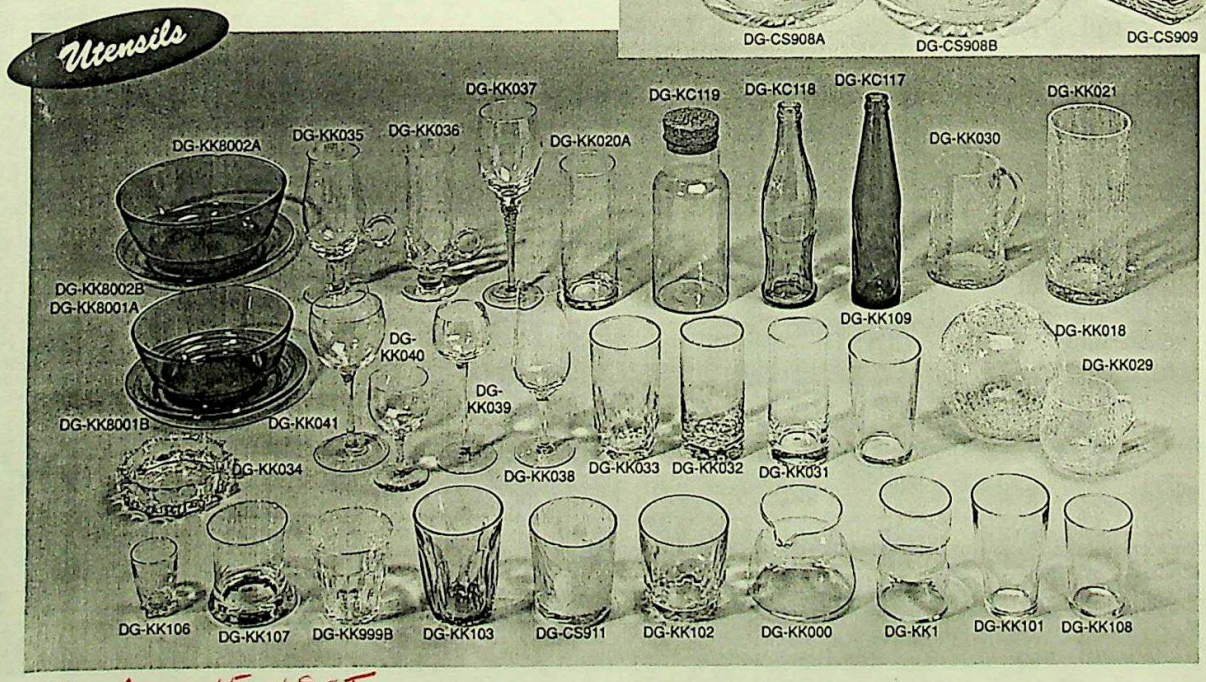

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㊹発明の名称　絵柄付き食器の製造方法および絵柄付き食器

㉑特　願　昭62－89348

㉒出　願　昭62(1987)4月11日

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⑪出願人　三信化工株式会社　東京都千代田区神田佐久間町2－8－1　神田シャンピアビル

⑭代理人　弁理士　三浦　光康

明　細　書

1．発明の名称

絵柄付き食器の製造方法および絵柄付き食器

2．特許請求の範囲

1）透明あるいは不透明なポリオレフィン樹脂材で食器の内側部材あるいは外側部材を成形する一次成形品成形工程と、この一次成形品成形工程を行うと同時に、あるいは該一次成形品成形工程で形成された内側部材の外側面あるいは外側部材の内側面に絵柄を形成する絵柄作成工程と、この絵柄作成工程を経た一次成形品を金型にインサートして不透明あるいは透明なポリオレフィン樹脂材で金型にインサートした一次成形品の外側あるいは内側に該一次成形品と融着一体となるように外側部材あるいは内側部材を成形する二次成形品成形工程とを含むことを特徴とする絵柄付き食器の製造方法。

2）一次成形品成形工程および二次成型品成形工程で使用される透明あるいは不透明なポリオレフィン樹脂材はポリプロピレン、ポリエチレンあるいはポリメチルペンテン（TPX）等であることを特徴とする特許請求の範囲第1項記載の絵柄付き食器の製造方法。

3）絵柄作成工程は一次成形品成形工程で成形された内側部材の外側面あるいは外側部材の内側面にパット印刷、スクリーン印刷、フィルム転写、ホットスタンプ等で絵、文字、記号あるいは写真等の絵柄を印刷することを特徴とする特許請求の範囲第1項または第2項記載の絵柄付き食器の製造方法。

4）透明あるいは不透明なポリオレフィン樹脂材で成形された食器の内側部材あるいは外側部材と、この食器の内側部材の外側面あるいは外側部材の内側面に形成した絵柄と、前記内側部材の外側部を覆うように、あるいは前記外側部材の内側部を覆うように融着固定された不透明あるいは透明なポリオレフィン樹脂材で形成された外側部材あるいは内側部材とからなることを特徴とする絵柄付き食器。

5）内側部材および外側部材は少なくとも 0.5㎜

以上の厚さであることを特徴とする特許請求の範囲第4項記載の絵柄付き食器。

3．発明の詳細な説明

「産業上の利用分野」

本発明は樹脂材で成形された絵柄付き食器の製造方法および絵柄付き食器に関する。

「従来の技術」

従来、合成樹脂材製食器に絵柄の付いたものとしては、例えば熱硬化性樹脂材のメラミン食器が知られている。

このメラミン食器は三度押しプレス成形によって作られている。その概要は、まずメラミン成形樹脂材を金型内に入れて型締めして溶融硬化させる。次に金型を開きフォイル（予め紙に絵柄を印刷し、メラミン樹脂材を含浸させたもの）を成形品の上に載せて金型を型締めし、フォイルと成形品を密着させる。次に金型を開きグレーズ（メラミン樹脂の粉）を少量入れて金型を型締めし、溶融流動させてフォイルの表面を薄くコーティングして成形されている。

このため、メラミン食器は三度押しプレス成形のため生産性が悪く、またフォイルは未硬化のメラミンを含浸させてあるため、保存中に自然硬化が進み保存寿命が短い等でコスト高となる欠点がある。さらに衝撃に弱く、熱湯や蒸気にも弱いという欠点がある。

熱可塑性樹脂材製の食器は、量産製の良い射出成形で主に製造され、ポリオレフィン樹脂材、特にポリプロピレン樹脂材製（ＰＰ）の食器は耐熱性や耐水性の良さや、衝撃に強く、広く使用されている。

しかしながら、このＰＰ食器に絵柄を付ける方法は限られており、表面に印刷してもインクとＰＰとの馴染みが弱く、インクの剥がれがおきやすいため実用的でない。また、ＰＰフィルムに予め印刷しておき、それを成形時に金型内にインサートして溶融樹脂材を射出し、フィルムと成形品とを密着させて絵柄を付ける方法も知られているが、フィルムと成形品との密着強度が十分でなく、特に絵柄の印刷されている部位はフィルムと成形品との間にインクが介在しているため密着力が弱い。

このため、煮沸や食器乾燥庫等で長期にわたって繰返しの加熱を受けたり、箸やフォーク等による傷や洗浄などによる摩擦等でフィルムが剥離してくるという欠点があった。

よって、ＰＰ食器そのものは広く使われているにもかかわらず、単色食器や二重成形による二色食器にとどまり、長期間の使用に耐えられる絵柄付き食器の製品化ができかねていた。

「本発明の目的」

本発明は以上のような従来の欠点に鑑み、絵柄が脱落しずらく、かつ耐熱性、耐水性に優れた安価に多量生産することのできる絵柄付き食器の製造方法および絵柄付き食器を得るにある。

「本発明の目的を達成するための手段」

本発明は透明あるいは不透明なポリオレフィン樹脂材で食器の内側部材あるいは外側部材を成形する一次成形品成形工程と、この一次成形品成形工程を行うと同時に、あるいは該一次成形品成形工程で形成された内側部材の外側面あるいは外側部材の内側面に絵柄を形成する絵柄作成工程と、この絵柄作成工程を経た一次成形品を金型にインサートして不透明あるいは透明なポリオレフィン樹脂材で金型にインサートした一次成形品の外側あるいは内側に該一次成形品と融着一体となるように外側部材あるいは内側部材を成形する二次成形品成形工程とを含むことを特徴としている。

また、本発明は透明あるいは不透明なポリオレフィン樹脂材で成形された食器の内側部材あるいは外側部材と、この食器の内側部材の外側面あるいは外側部材の内側面に形成した絵柄と、前記内側部材の外側部を覆うように、あるいは前記外側部材の内側部を覆うように融着固定された不透明あるいは透明なポリオレフィン樹脂材で形成された外側部材あるいは内側部材とからなることを特徴としている。

「本発明の実施例」

以下、図面に示す実施例により、本考案を詳細に説明する。

第１図ないし第４図の実施例において、１は透

明なポリプロピレン、ポリエチレン、ポリメチルペンテン（TPX）等のポリオレフィン樹脂材で少なくとも 0.5㎜以上の厚さとなる食器の内側部材2を成形する一次成形品成形工程で、この一次成形品形成工程1は量産性の良い射出成形によって行なう。

3は前記一次成形品成形工程1で成形された内側部材2の外側面に絵柄4を形成する絵柄作成工程で、この絵柄作成工程3はパット印刷、スクリーン印刷、フィルム転写、ホットスタンプ等で、絵、文字、記号あるいは写真等の絵柄4を内側部材2の外側面に印刷するものである。

5は前記絵柄作成工程3を経た内側部材2Aを金型6にインサートして不透明なポリオレフィン樹脂材で該金型6にインサートした内側部材2Aの外側に該内側部材2Aと融着一体となり、かつ少なくとも 0.5㎜以上の厚さとなる外側部材7を射出成形して絵柄付き食器8を形成する二次成形品成形工程で、この二次成形品成形工程5で用いるポリオレフィン樹脂材は前記一次成形品成形工程1で用いた樹脂と同じものを用いると良い。

「本発明の異なる実施例」

次に第5図ないし第16図に示す本考案の異なる実施例につき説明する。なお、これらの実施例の説明に当って、前記本考案の実施例と同一構成部分には同一符号を付して重複する説明を省略する。

第5図ないし第8図の実施例において、前記本発明の実施例と主に異なる点は一次成形品成形工程1を不透明なポリオレフィン樹脂材で外側部材7を成形した点、絵柄作成工程3で外側部材7の内側面に絵柄4を形成した点および二次成形品成形工程5で外側部材7の内側に内側部材2を融着一体化させた点で、このようにして絵柄付き食器8を製造しても良い。

第9図ないし第12図の実施例において、前記本発明の実施例と主に異なる点は、内側部材2と外側部材7とを透明なポリオレフィン樹脂材で形成した点で、このようにして絵柄付き食器8Aを製造しても良い。

第13図ないし第16図の実施例において、前記本発明の実施例と主に異なる点は、一次成形品成形工程1で製造される内側部材2に、二次成形品成形工程5時に溶融樹脂の流入部位となる所を厚肉となるように厚肉部9を形成した点で、このように構成することにより、二次成形品成形工程5時に一次成形品成形工程1で製造された内側部材2がえぐられたりするのを効率良く防止することができる。

なお、前記本発明の実施例では内側部材と外側部材とを同一の材質のポリオレフィン樹脂材で形成したものに付いて説明したが、本発明はこれに限らず、内側部材と外側部材とが融着一体となる材質同志で有れば、異なる材質のポリオレフィン樹脂材を用いても良い。

また、本発明は内側部材不透明なポリオレフィン樹脂材で成形し、外側部材を透明なポリオレフィン樹脂材で成形した食器にしても良い。

さらに、前記本発明の実施例では一次成形品成形工程の後で、絵柄作成工程を行うものに付いて説明したが、本発明はこれに限らず、一次成形品成形工程時に同時に行っても良い。この場合、金型に絵柄付きフィルムをセットすれば良い。なお、絵柄付きフィルムは一次成形より外しても良く、あるいは一次成形に付着したまま二次成形品成形工程を行い、内部にインサートしても良い。

「本発明の効果」

以上の説明から明らかなように、本発明にあっては次に列挙する効果がある。

（1）透明あるいは不透明なポリオレフィン樹脂材で食器の内側部材あるいは外側部材を成形する一次成形品成形工程と、この一次成形品成形工程を行うと同時に、あるいは該一次成形品成形工程で形成された内側部材の外側面あるいは外側部材の内側面に絵柄を形成する絵柄作成工程と、この絵柄作成工程を経た一次成形品を金型にインサートして不透明あるいは透明なポリオレフィン樹脂材で金型にインサートした一次成形品の外側あるいは内側に該一次成形品と融着一体となるように外側部材あるいは内側部材を成形する二次成形品成形工程とからなるので、絵柄が食器の内側部材

と外側部材との間に介在されているので、箸やフォーク等の傷や、洗浄等で摩擦しても従来のように剥がれたり、インクが剥げ落ちたりするのを防止できる。したがって、長期間絵柄がいたむことなく使用することができる。

(2) 前記(1)によって、射出成形で絵柄付き食器を製造することができるので、量産することができ、安価に製造することができる。

(3) 前記(1)によって、ポリオレフィン樹脂材を使用しているので、耐熱性や耐水性が良く、衝撃にも強い絵柄付き食器を製造することができる。

(4) 内側部材あるいは外側部材のいずれか一方を透明にしているので、透明層を通して絵柄が見えるので、深みのある高級感を持たせることができる。

4. 図面の簡単な説明

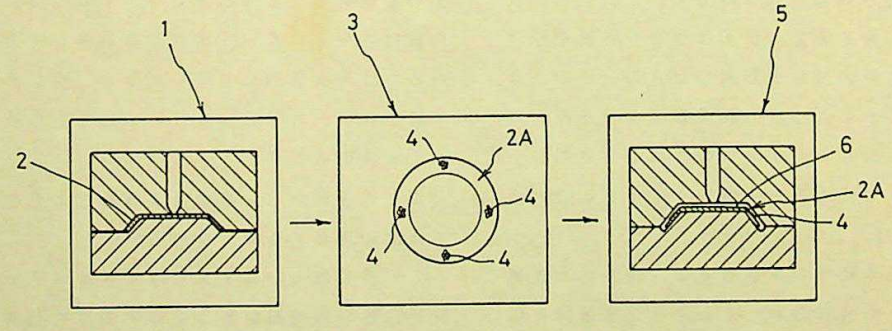
第1図は本発明の一実施例を示す工程図、第2図は食器の内側部材の断面図、第3図は絵柄を付けた内側部材の背面図、第4図は絵柄付き食器の断面図、第5図ないし第8図、第9図ないし第12図、第13図ないし第16図はそれぞれ本発明の異なる実施例を示す説明図である。

1：一次成形品成形工程、
2：内側部材、　3：絵柄作成工程、
4：絵柄、
5：二次成形品形成工程、
6：金型、　7：外側部材、
8：絵柄付き食器、　9：厚肉部。

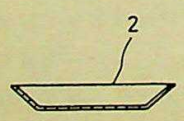
特許出願人

大日本印刷株式会社
三信化工株式会社

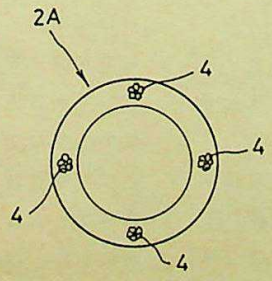
第1図



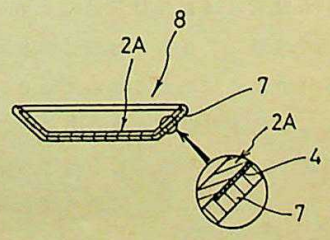
第2図



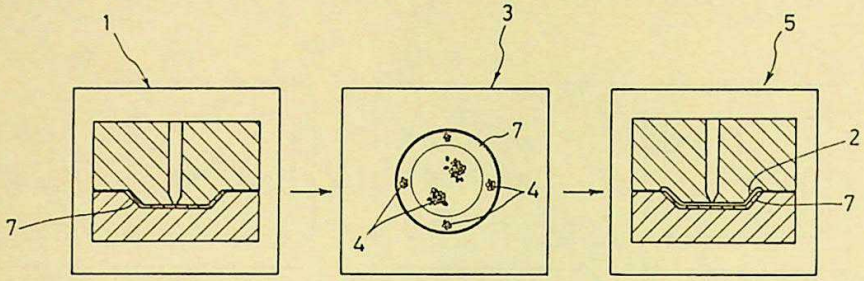
第3図



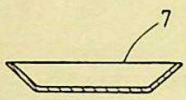
第4図



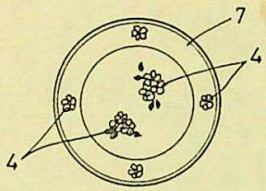
第 5 図



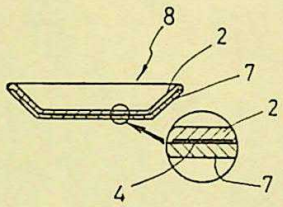
第 6 図



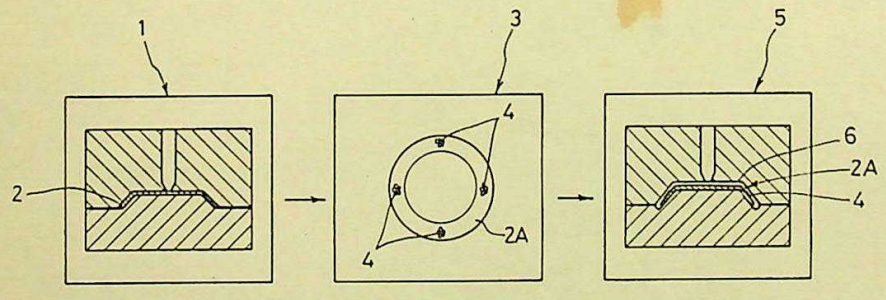
第 7 図



第 8 図



第 9 図



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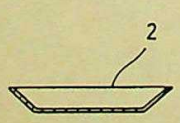
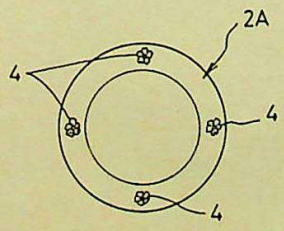
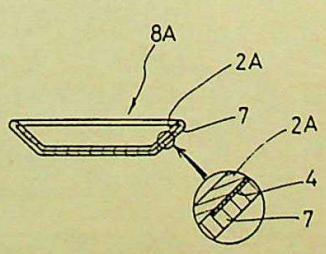


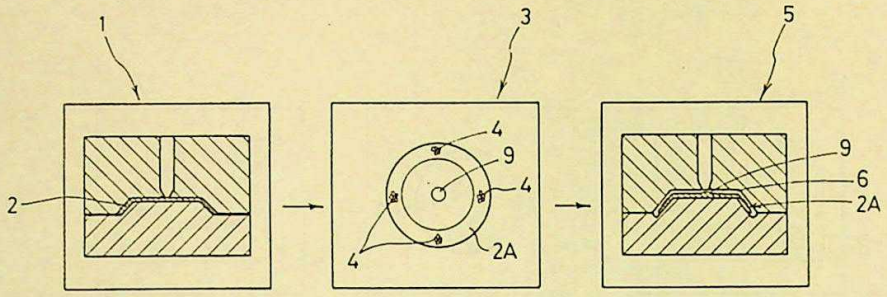
第 11 図



第 12 図



第 13 図



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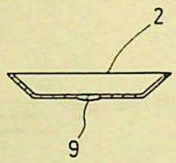
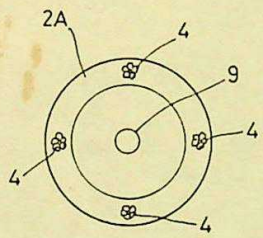
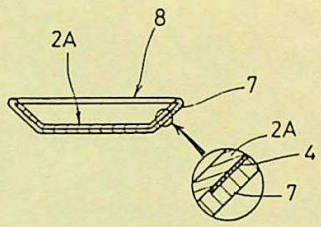


第 15 図



第 16 図

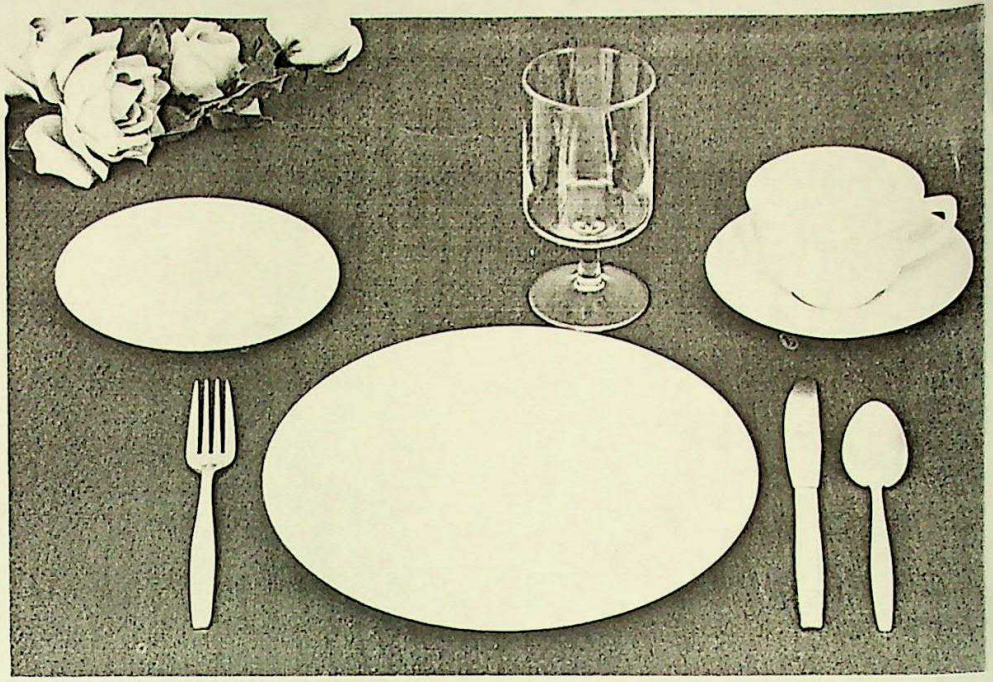


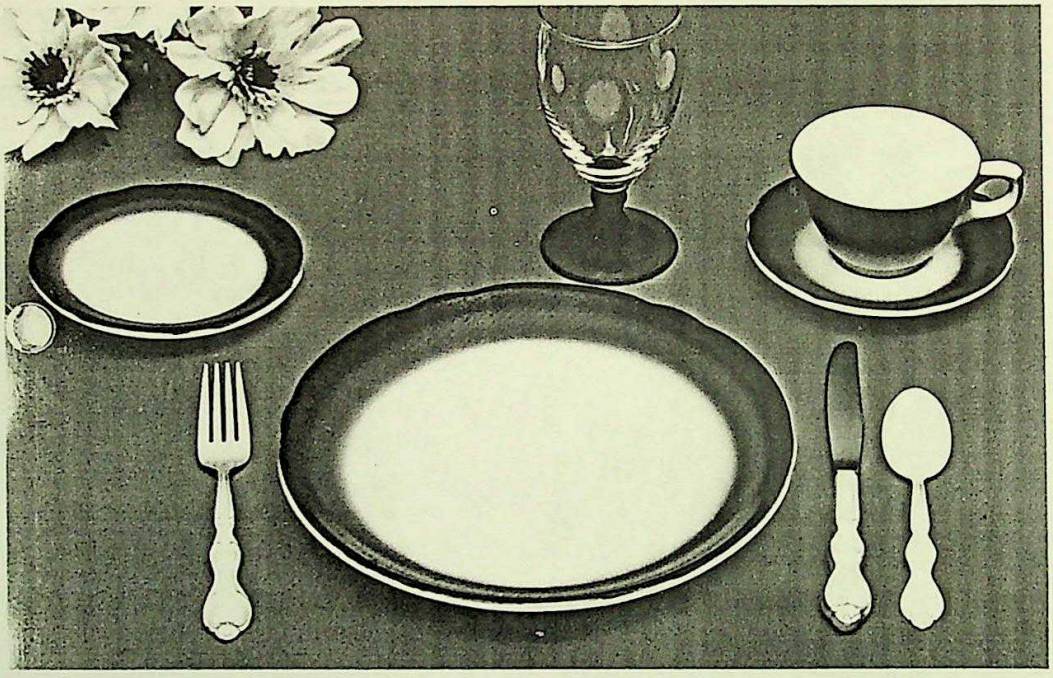
D 7/568

SWIRL WHITE

Bouillons U/H Swirl 7½ oz.
Dishes (Platters) Swirl #8 – 11-5/8"
Fruits Swirl #3½ – 4-5/8"
Grapefruits Swirl #1 – 6-7/8"
Plates Swirl #3 – 5-5/8"
Plates Swirl #4 – 6¼"
Plates Swirl #5 – 7¼"
Plates Swirl #7 – 9-3/16"
Plates Swirl #8 – 9-7/8"
Plates Swirl #10 – 10-5/16"
Tea Cups Swirl 7½ oz.
Tea Saucers Swirl 5-7/8"

Jackson China
6/27/1972



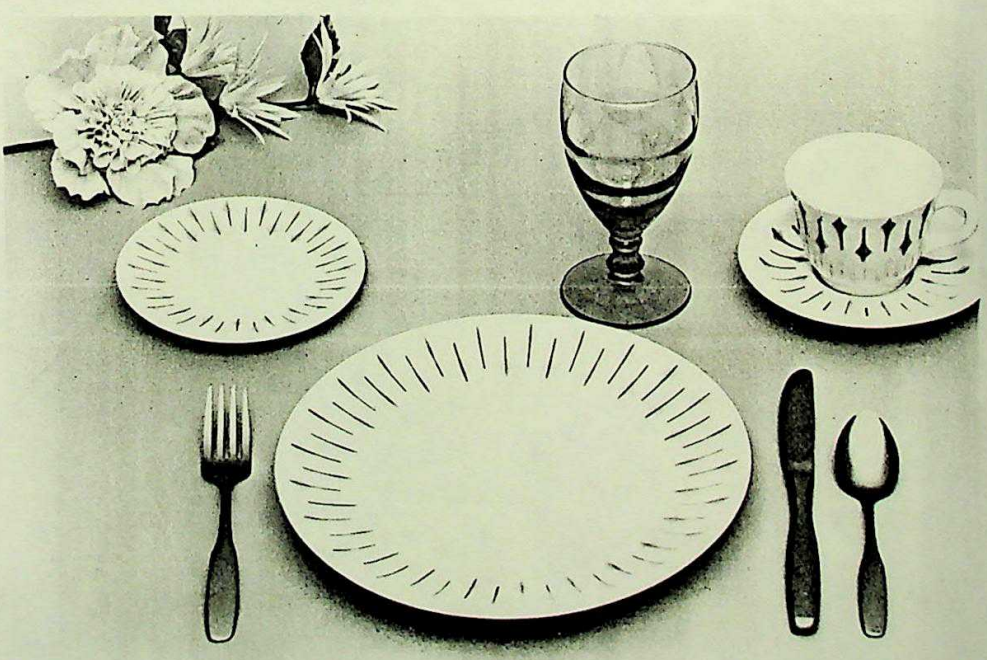


VELVET

Bouillons U/H Bellford 7 oz.
Dishes (Platters) Carlton #7 – 10¼"
Dishes (Platters) Carlton #8 – 11½"
Dishes (Platters) Carlton #9 – 12½"
Fruits Carlton #4 – 4-7/8"
Grapefruits Carlton #1 – 6¼"
Plates Ritz #3 – 5-5/8"
Plates Ritz #4 – 6½"
Plates Ritz #5 – 7-3/8"
Plates Ritz #7 – 9"
Plates Ritz #8 – 9-7/8"
Plates Ritz #10 – 10-3/8"
Tea Cups Bellford 7 oz.
Tea Saucers Carlton 5¾"

ELITE

Bouillons U/H Tulip 8 oz.
Dishes (Platters) NR #6 – 9¾"
Dishes (Platters) NR #7 – 10¾"
Dishes (Platters) NR #8 – 11-3/8"
Fruits NR #4 – 4-7/8"
Grapefruits RE #1 – 6¼"
Plates Roosevelt #3 – 5¾"
Plates Roosevelt #4 – 6½"
Plates Roosevelt #5 – 7-3/8"
Plates Roosevelt #7 – 9-1/8"
Plates Roosevelt #8 – 9¾"
Plates Roosevelt #10 – 10-3/8"
Tea Cups Boston 7 oz.
Tea Cups K&T 7½ oz.
Tea Cups Seneca 7 oz.
Tea Saucers Vernon 5-5/8"



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D7/568

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■ **B. Fudge Sauce.** This wickedly intense, chocolate extravagance will intoxicate even the most jaded. A velvet fantasy to lavish on ice cream and other desserts. **Dansk Store Price $8.**

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D7-30 XR D7-570

platters

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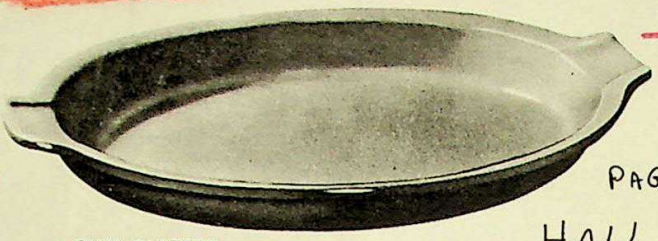
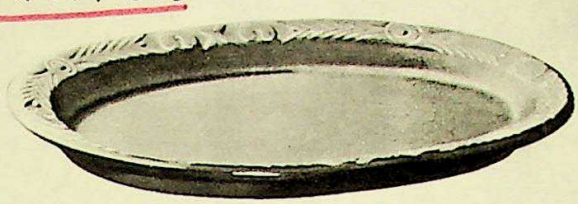


PAGE 7

HALL SERVICE CHINA CATALOG



OVAL PLATTER

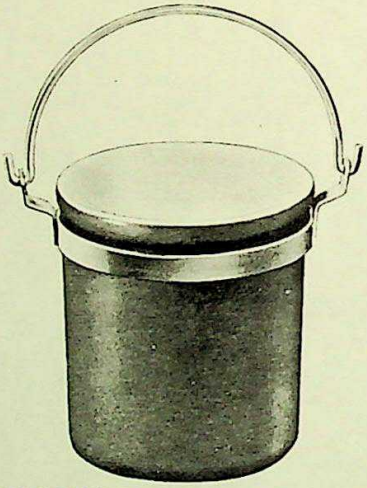
	Length	Width	Height
#2184	11⅝"	8¼"	1⅜"
#2185	13¼"	9½"	1½"
#2199	15⅜"	11"	1½"

#792 PLATTER—embossed
Length 11" ..... Width 7½"

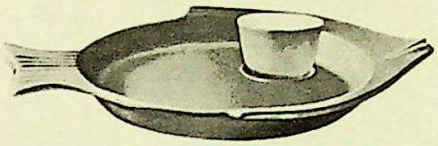
#795 PLATTER—not embossed
Length 11" ..... Width 7½"

seafood service

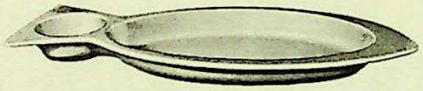
#232 CRAB SHELL ..... 3 oz.



#301 H BUCKET
with metal handle ..... 1 qt.
#302 H ..... 2 qts.

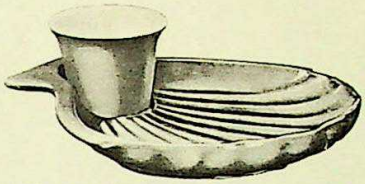


#291 FISH ENTREE DISH
with well for #1787
Length .... 12" Width ... 9½"
#1787 RAMEKIN ..... 1½ oz.
fits well of # 291

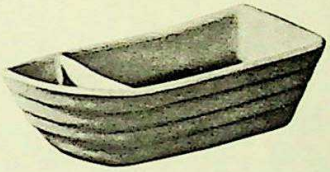


#1235 FISH PLATTER
with 2 oz. sauce well
L .. 15" W .. 6⅞" Ht .. 1⅛"

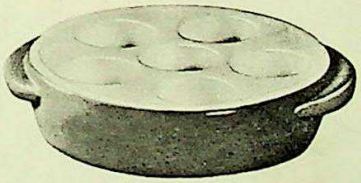
#1152 SNAIL POT ..... ½ oz.
#1153 ..... ¾ oz.



#1520 OYSTER COCKTAIL ..... 2 oz.
#1522 SEAFOOD SHELL ..... 8 oz.

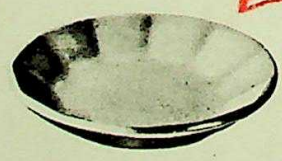


#1145 SHRIMP BOAT ..... 6 oz.
with 1½ oz. sauce well



#1154 SNAIL DISH
Diameter ..... 6¼"

miscellaneous



#605 ASH TRAY
Diameter ..... 3⅞"

#2686 SALT
Height ..... 2¾"
#2687 PEPPER
Height ..... 2¾"

#666 ASH TRAY
Diameter ..... 5½"

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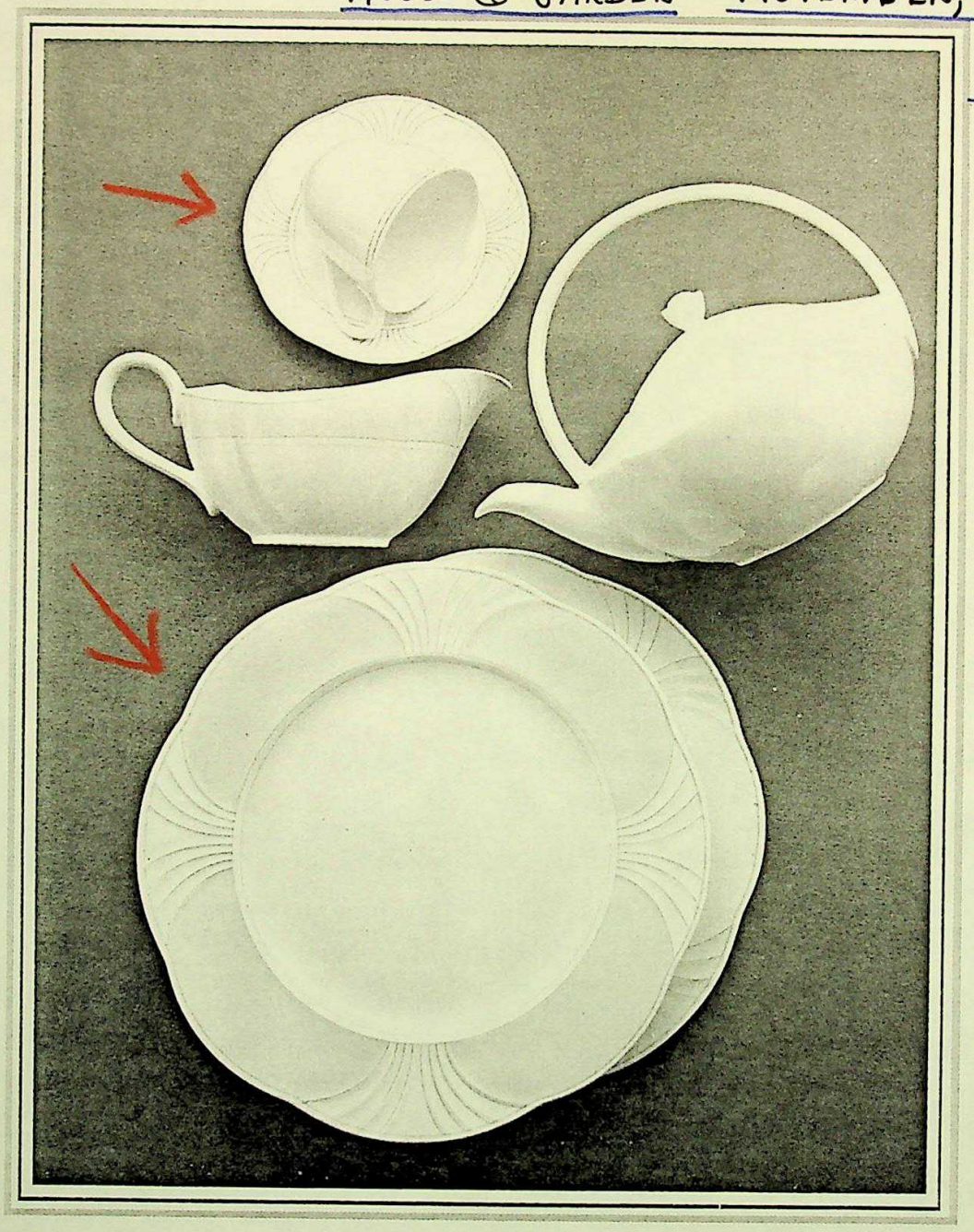
D7/~~30~~ 570 D7/570

"DESIGN EXCELLENCE: GERMANY"

V&B has been selected by *Harper's Bazaar* to be featured in the October 1985 issue.

HOUSE & GARDEN NOVEMBER, 1985

PAGE 101



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